

100			0.00			
100	FLOW WATER JET				DAS	
Waterjet	Memo		0.00	(4)	46	17/08/01
FLOW CNC Waterjet	1-Cut as per Dwg D3224				9-89	
	Dwg Rev: <u>3</u>					
	Prog Rev: <u>3</u>					
	2-Deburr if necessary					
110			0.00			
110	QC2- Inspect parts off machine FAI/FAIB				DAS	
QC	Memo		0.00	(4)	46	17/08/01
Quality Control					9-89	

Work Order ID 120263

120263

Page 2

Item ID: D3224-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Frame

Stop

NS2

Start Date: 6/04/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(4)

DAS
38
9-89

14/08/07

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Debur

DAS
30
9-89

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3224

4x

DAS
36
9-89

14/08/07

Work Order ID 120263***120263***

Page 3

Item ID: D3224-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Frame

Stop ***NS2***

Start Date: 6/04/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number DAS	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				(4)	RD	38 9-89	14/08/07
150 QC Quality Control	Memo	0.00							
160	Chemical Conversion Coat per QSI005 4.1	0.00				4		7/14-8-7	
160 HandFinish Hand Finishing	Memo	0.00							
170	QC7-Inspect Chemical Conversion Coat	0.00				4		14/08/07	
170 QC Quality Control	Memo	0.00							

Work Order ID 120263

August-01-14 7:37:04 AM

120263

Page 4

Item ID: D3224-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Frame
 Start Date: 6/04/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging	57436								14/8/14 (4)
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									14-08-11
									14.8.7

Picklist Print

August-01-14 7:37:04 AM

Page 1

Work Order ID: 120263

120263

Parent Item: D3224-1

D3224-1

Parent Item Name: Frame

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	123.6339	5.2	66			
M2024T3S 063												DAS	
2024-T3 .063 sheet												46	17/08/01
												9-89	

Location

Loc Qty

Loc Code

MAT022

123.6339

123701

16.1039

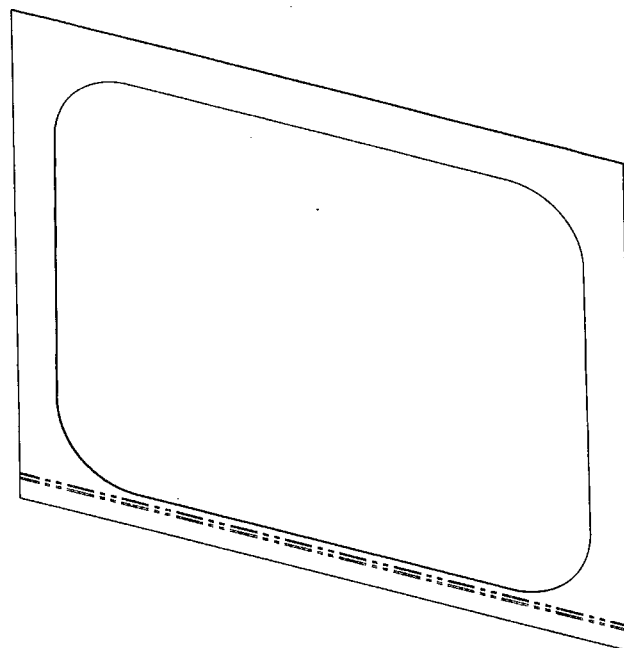
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31.93

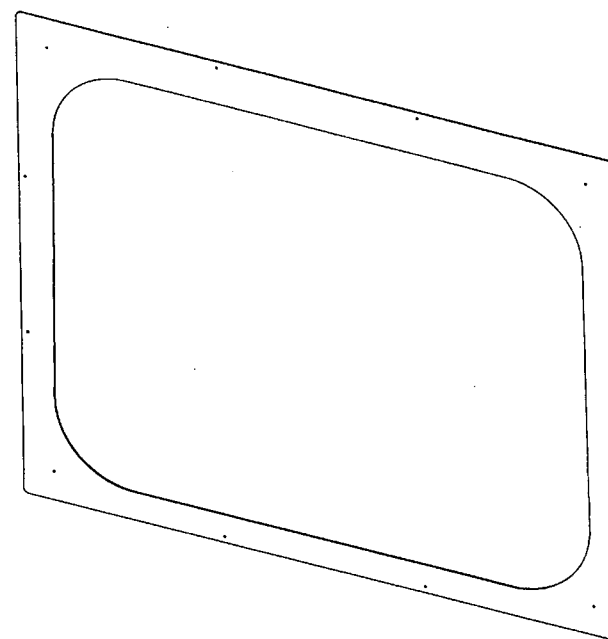
m128354

75.6

17.



D3224-1 FRAME



D3224-3 FRAME

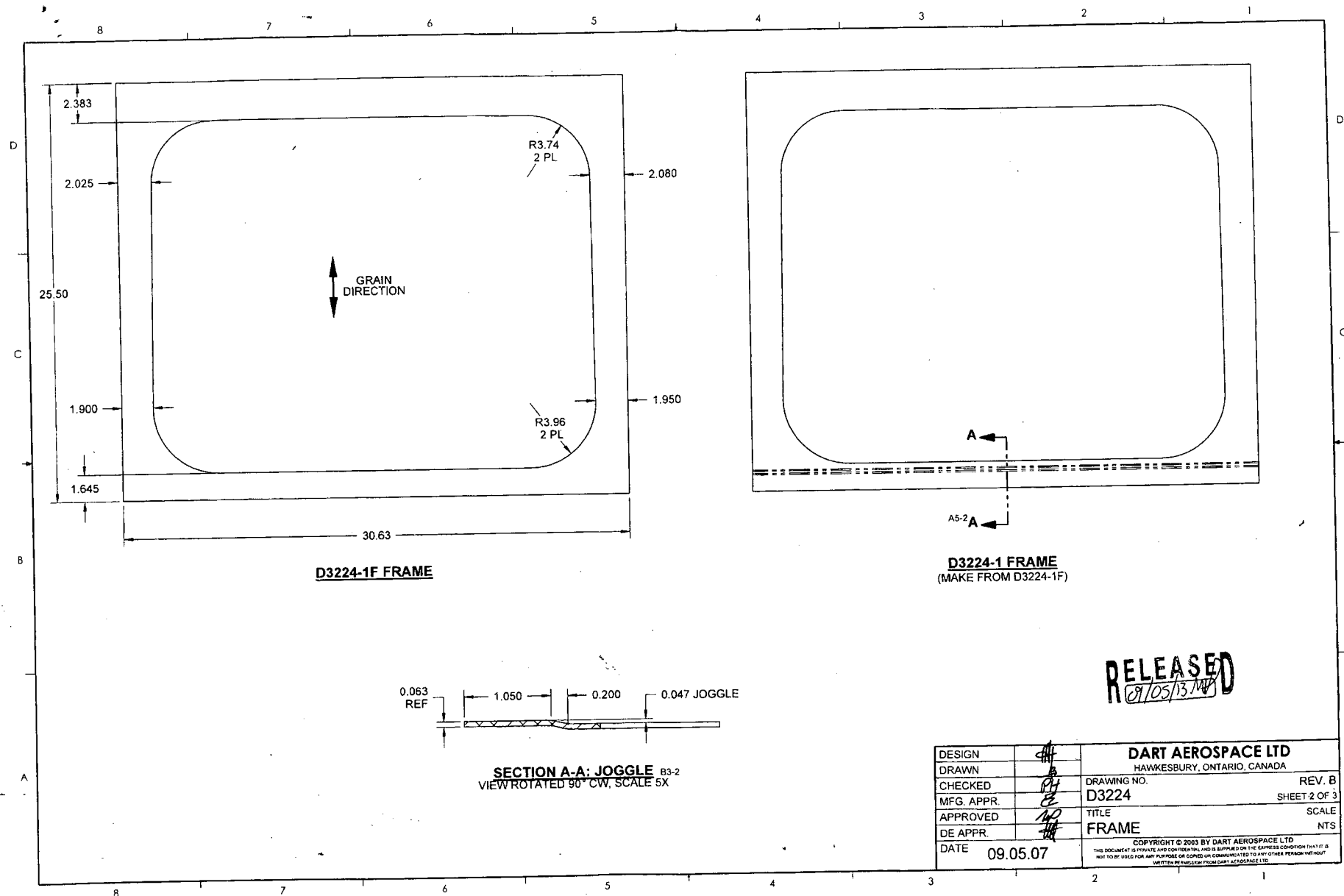
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 120263 MLJ
1406-05

RELEASED
09/05/13/10

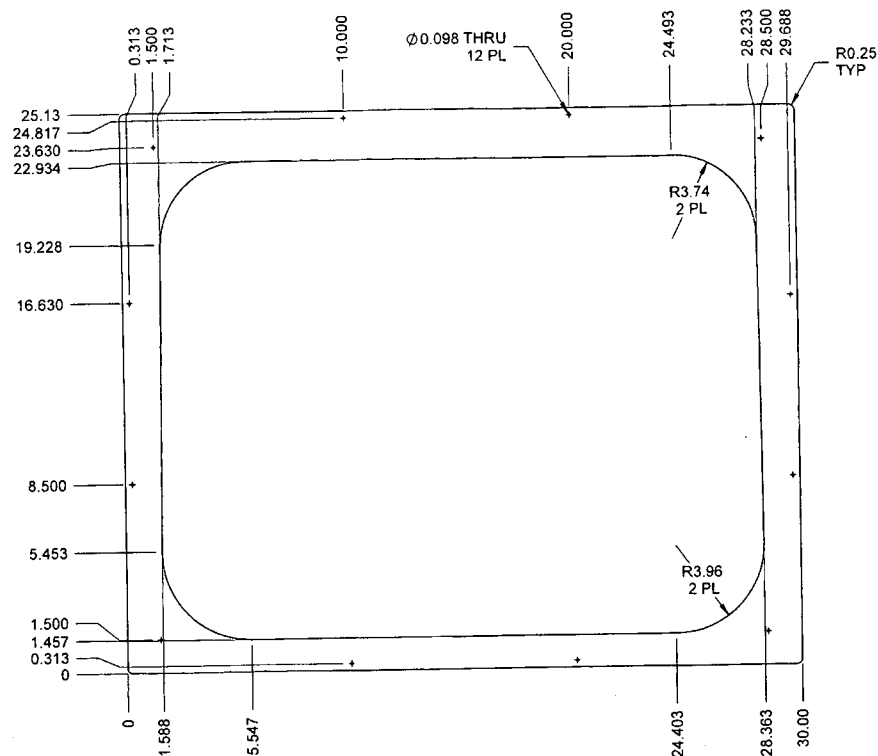
- NOTES:**
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037
REF. DART SPEC. M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3224-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT:
D3224-1 = 1.40 lbs
D3224-3 = 1.22 lbs

B	REDRAWN TO CURRENT DRAWING STANDARDS; ADDED D3224-1F AND D3224-3. REASON: SEE NCR#09-054.	MB	09.05.07
A	NEW ISSUE	RF	03.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3224	SHEET 1 OF 3
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DE APPR.		FRAME	NTS
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D3224-3 FRAME

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